

Date: Thursday, 11/29/2007 11:01:03 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BO 105 SKID TUBE 'I' BEAM		
Job Number	36015					
Estimate Number	11075					
P.O. Number	N/A		Part Number	D2976		
This Issue	11/29/2007	S.O. No.	Drawing Number	D2976 REV A1		
Prsh Rev.	NC		Project Number	N/A		
First Issue	N/A	Type	Drawing Revision	A1		
Previous Run	33545		Material	N/A		
Written By			Due Date	12/5/2007	Qty:	2 Um: Each
Checked & Approved By						
Comment	Est. C	02.10.30 Re-format KJ				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2963084	105 I Beam Extrusion	
		Comment: Qty.: 4.5938 Each(s)/Unit Total : 9.1875 Each(s)	
		Extrusion 'I Beam' thin	
		Pick:	
		Qty Part Number Description Batch	
	1 D2963-084 Extrusion	B14459	DP 2-11-30
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		Cut D2963-084 extrusion to length: (82.00")	
		Use Jig DT8546 to drill pilot holes	
		Open holes to finish size per dwg D2976	
		Deburr	
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Acid etch and Alodine as per QSI 005 4.1	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Identify and Stock	
		Location: 4/6	
		DP 2-11-30	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKID TUBE 'I' BEAM

Job Number: 36015

Part Number: D2976

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

11/29/2004

Job Completion



W. D. 11/29/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

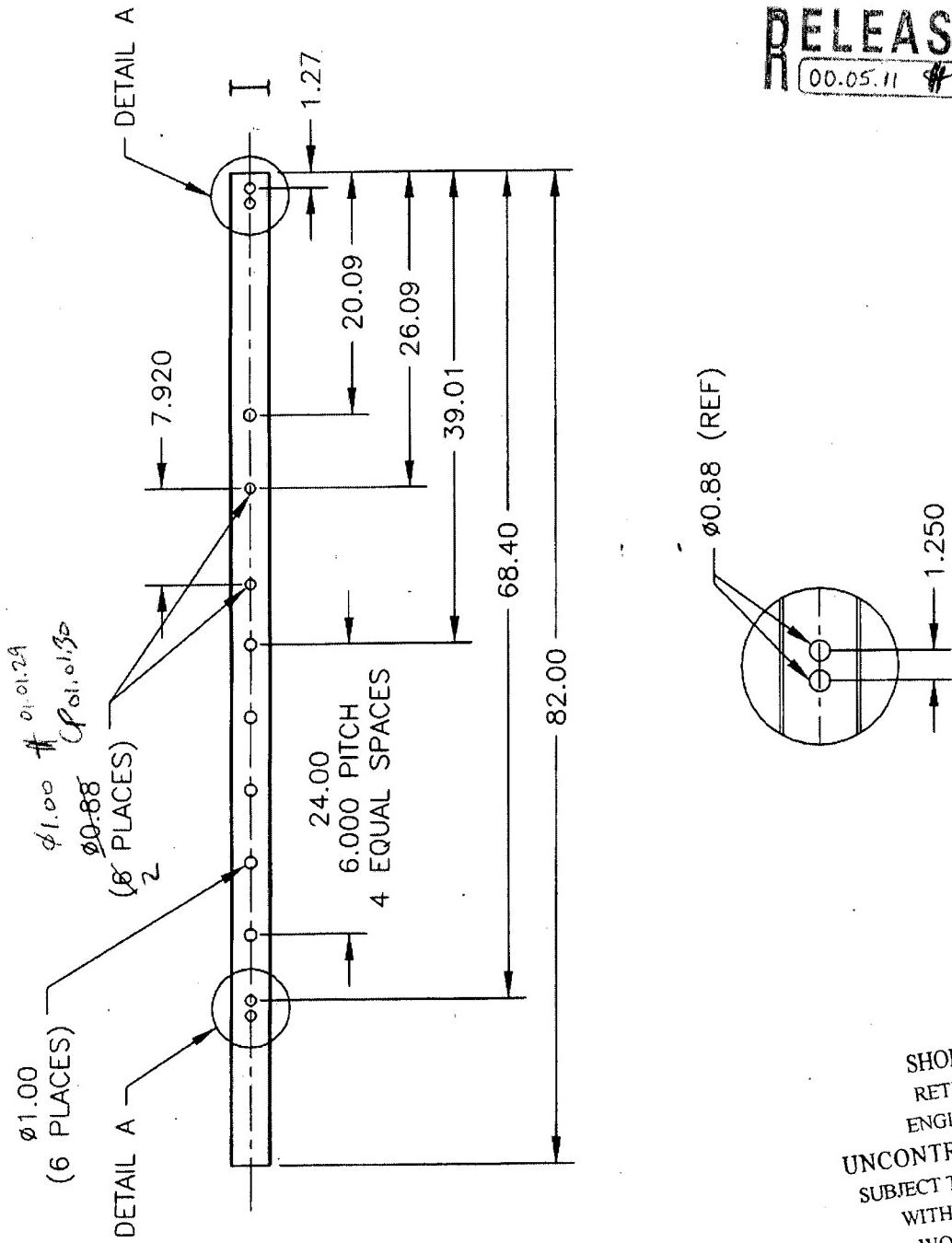
NOTE: Date & initial all entries



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DRAFT

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2976
DATE 00.03.14		TITLE WEB
		SCALE 1:14
A	00.03.14	NEW ISSUE
A1	01.01.29	OPEN GROUND HANDLING HOLES TO $\phi$ 1.00

RELEASED  
00.05.11 *#*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36015

MAKE FROM D2963-084 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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